

Work Order ID 63124

Thursday, October 21, 2010 1:28:04 PM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Receiver Assembly

Start Date: 10/21/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-21

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3912	B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	1-Assemble D3912-1/-3/-5 and install rivets as per dwg TRIM RIVETS 1.250" LONG								
	2- Install helical, spring plunger and spring pin lanyard assy as per dwg								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

EF 10/10/25 (2)

EF 10/10/25 (2)

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item Name: Eyebolt Receiver Assembly

Start Date: 10/21/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 507

0.00



Packaging

Memo

0.00

Packaging

10/12/2010

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/2010
MF 10-10-25

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Picklist Print

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Page 1

Work Order ID: 63124

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly




Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3912-1  Eyebolt		Manufactured	No			100	Each	10.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG095				4					
					61081			4					
				FG096				6					
					59441			6					
D3912-3  Eyebolt Block		Manufactured	No			100	Each	18.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST096				18					
					59430			6					
					61835			12					
D3912-5  Eyebolt Plate		Manufactured	No			100	Each	22.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST096				22					
					61078			7					
					61836			15					

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 2

Thursday, October 21, 2010 1:28:08 PM

Work Order ID: 63124

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

D3801-1 Manufactured No

Each 16.0000 1



Hand Retractable Spring Plunger

Location

Loc Qty

Loc Code

ST088

16

40736

2

56905

14

MS20615-4M20 Purchased No

100 Each 266.0000 8



RIVET

Location

Loc Qty

Loc Code

ST323

266

114808

96

115054

170

MS21209-F615 Purchased No

Each 97.0000 1



Heli-Coil

Location

Loc Qty

Loc Code

ST305

97

108170

76

108244

21

NAS1149F032P Purchased No

Each 567.0000 1



WASHER

Location

Loc Qty

Loc Code

ST275

567

18057

567

AN 960C 616
66312 on stake 1st w/o
W
MP/85 (24)

2
E/S 10/10/25

2
E/S 10/10/25

2
E/S 10/10/25

2
E/S 10/10/25

Thursday, October 21, 2010 1:28:08 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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W/O: 63124		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.08.10	100	PERMANENT CHG. T1P0 ON B.O.M. CHANGE NAS1149033P to NAS11490663R. 119185 (2x) A/N 96 C616	EF	10/08/10	2	10.08.10 asl atz	10/04/10

Part No: D3912-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, August 05, 2010 11:35:20 AM

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Work Order ID: 61077

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

D3801-1
Hand Retractable Spring Plunger
Manufactured No

MS20615-4M20
RIVET
Purchased No

MS21209-F615
Heli-Coil
Purchased No

NAS1149F0327 6632 10.08.10
WASHER
Purchased No

PTC



Location Loc Qty

ST088 18
40736 2
56905 16

100 Each

Location Loc Qty

ST323 282
114808 112
115054 170

Each

Location Loc Qty

ST305 99
108170 78
108244 21

Each

Location Loc Qty

ST275 619
18057 619

Start Date: 8/5/2010

Required Date: 8/12/2010

Start Qty: 2.00

Required Qty: 2.00

18.0000

Loc Code

282.0000

Loc Code

99.0000

Loc Code

619.0000

Loc Code

1 2
8/5/08/09
2
16
8/5/08/09
16
1
8/5/08/09
2
1
8/5/08/09
2

Thursday, August 05, 2010 11:35:20 AM

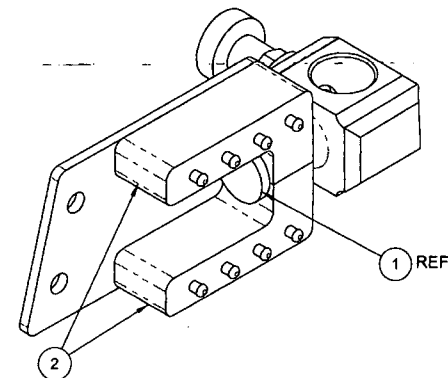
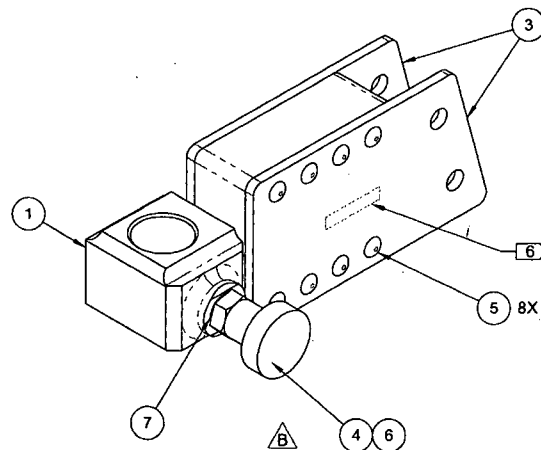
Shop Packet Print

Page 2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43124

12/10/21

ITEM	QTY .041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20815-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT .041: 1.58 lbs

RELEASED
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ASS		
DRAWN	JH		
CHECKED	JH		
MFG. APPR.	JH		
APPROVED	JH		
DE APPR.	JH		
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
TITLE **EYEBOLT RECEIVER ASSY** NTS
SCALE

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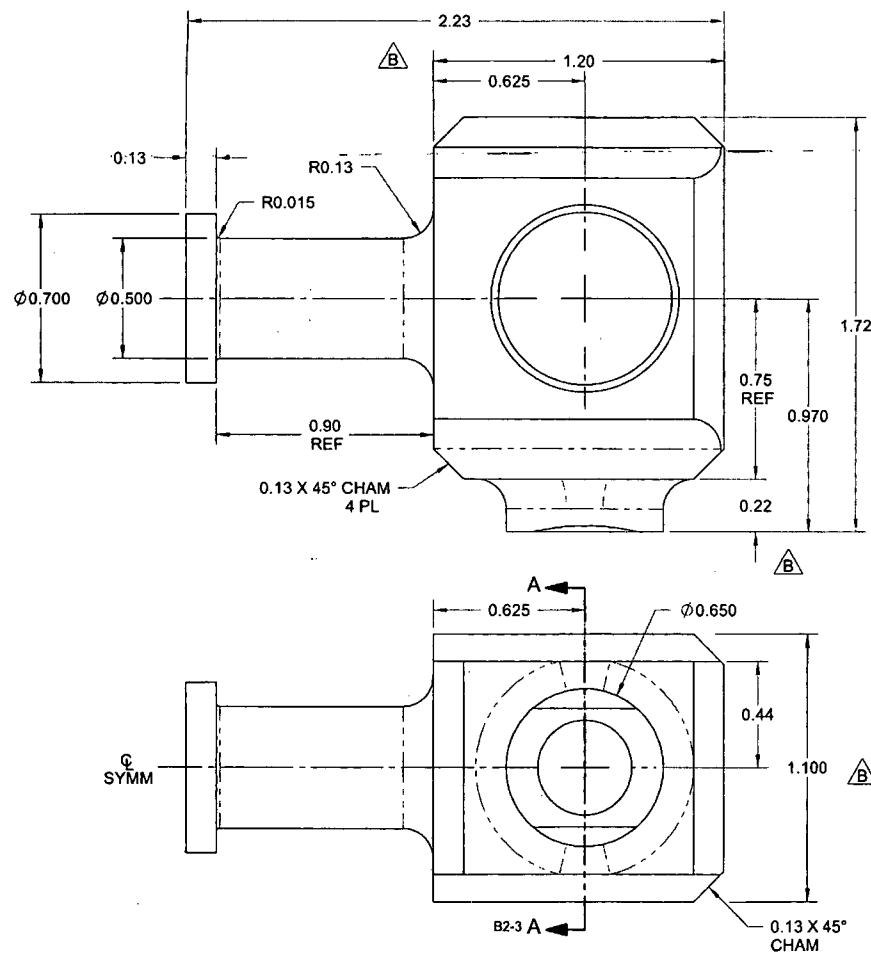
Dart Aerospace Ltd

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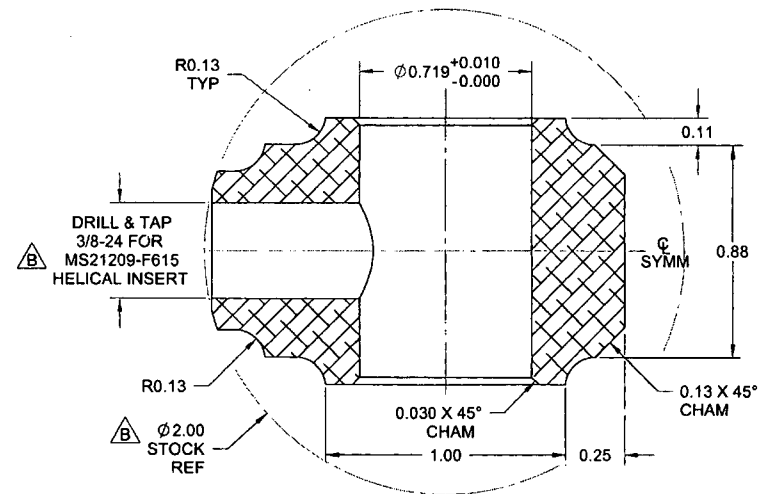
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D3912	SHEET 2 OF 3
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	EYEBOLT RECEIVER ASSY	NTS
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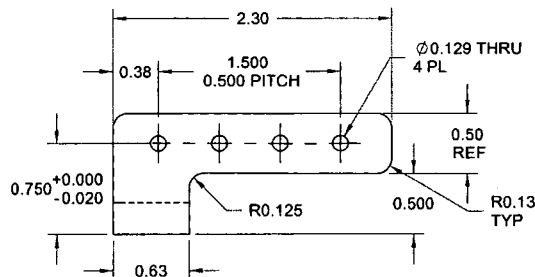
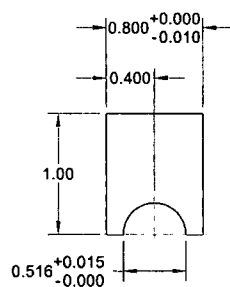
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

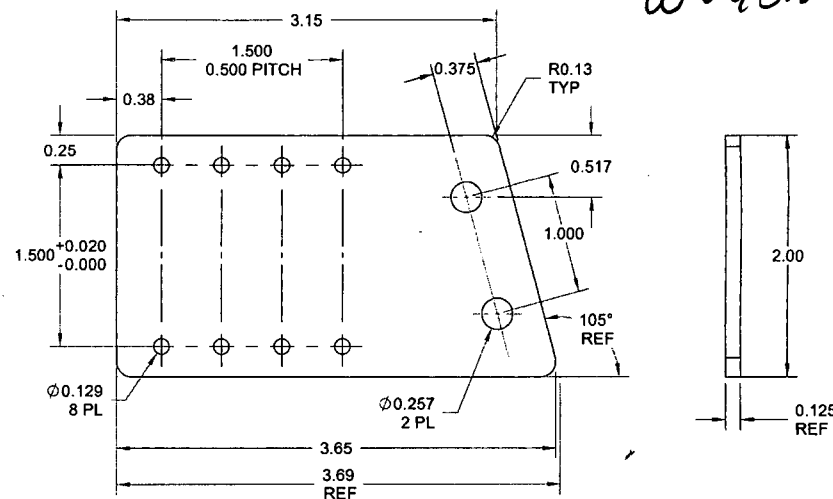
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D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16

DESIGN	115	DART AEROSPACE LTD	
DRAWN	115	HAWKESBURY, ONTARIO, CANADA	
CHECKED	115	DRAWING NO.	REV. B
MFG. APPR.	115	D3912	SHEET 3 OF 3
APPROVED	115	TITLE	SCALE
DE APPR.	115	EYEBOLT RECEIVER ASSY	NTS
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